

Work Order ID 74774

Thursday, October 06, 2011 11:30:35 AM

74774

Ship Oct 11th Page 1

Item ID: D2656-13 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID:
 Item Name: Wearplate Stop ***NS2***
 Start Date: 10/6/2011 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 10/11/2011 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: mf Date: 11-10-11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2656	Rev D								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2656 Dwg Rev: <u>D</u> Prog Rev: <u>D</u> 2-								
1010, 040	Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

B11-10-6

(3)

B11-10-6

(53)

81110607

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00							
130									
Brake NC	Memo	0.00							
Brake NC	1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT83262-Form joggle as per Dwg D2656 using Jig DT8158 Identify as D2656-13								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 2:00								
	FINISH TIME: 3200								
		2:30							

M118486

11/10/11

8 11/10/11

3x Ø m-f 11/10/11

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N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 10/6/2011 **Start Qty:** 3.00

3

Required Date: 10/11/2011 **Req'd Qty:** 3.00

3

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

0.00

160

QC

Memo

0.00

Quality Control

3 ϕ H H H H H
COUNT MEASURE

Identify as per dwg & Stock Location: F7

0.00

170

Packaging

Memo

0.00

Packaging

11/10/21 SP 30

QC21- Final Inspection - Work Order Release

0.00

180

OC

Memo

0.00

Quality Control

11/10/12

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Picklist Print

Thursday, October 06, 2011 11:04:30 AM

Page 1

Work Order ID: 74774

74774

Parent Item: D2656-13

D2656-13

Parent Item Name: Wearplate

Start Date: 10/6/2011

Required Date: 10/11/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP: F 02.10.25Re-formatKJ/RF
IPP Rev:G Now on Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S20GA		Purchased		No		100	sf	129.7000	0.85	2.55			

M1010S20GA

1010/1025 SHEET

**

10-11-10-6

Location

Loc Qty

Loc Code

MAT019

129.7

111410

53.2

116791

76.5

111410

(3)

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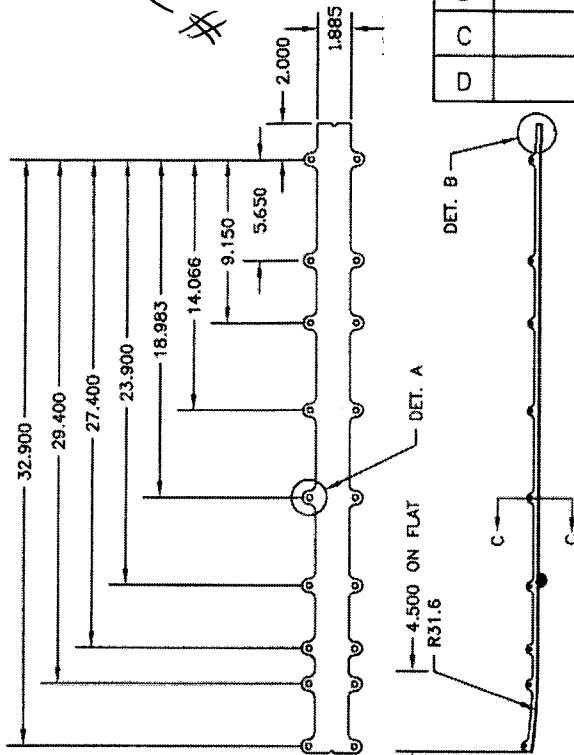
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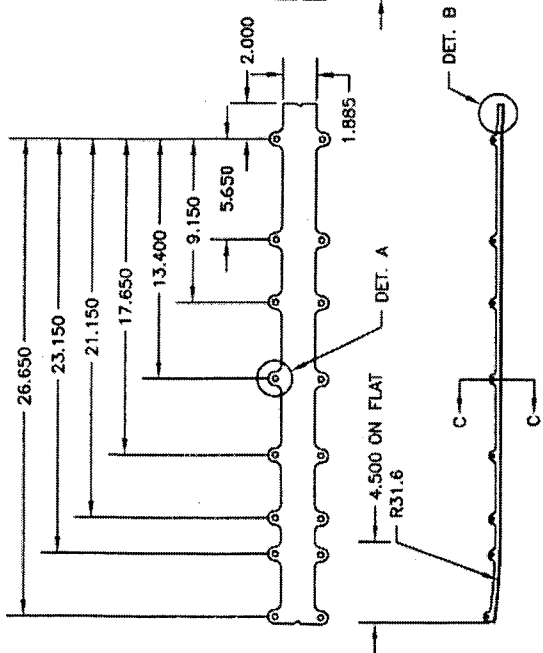


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CHECKED [Signature]		APPROVED [Signature]		DRAWING NO. D2656	REV. D SHEET 1 OF 4
DATE 05.08.17		TITLE WEARSHOE			SCALE 1:10
A	97:03:25		NEW ISSUE		
B	97:06:02		CHANGED TABS		
C	97:06:26		R31.6 WAS R19.5		
D	05.08.17		ENLARGE ALL HOLES TO IMPROVE FIT		

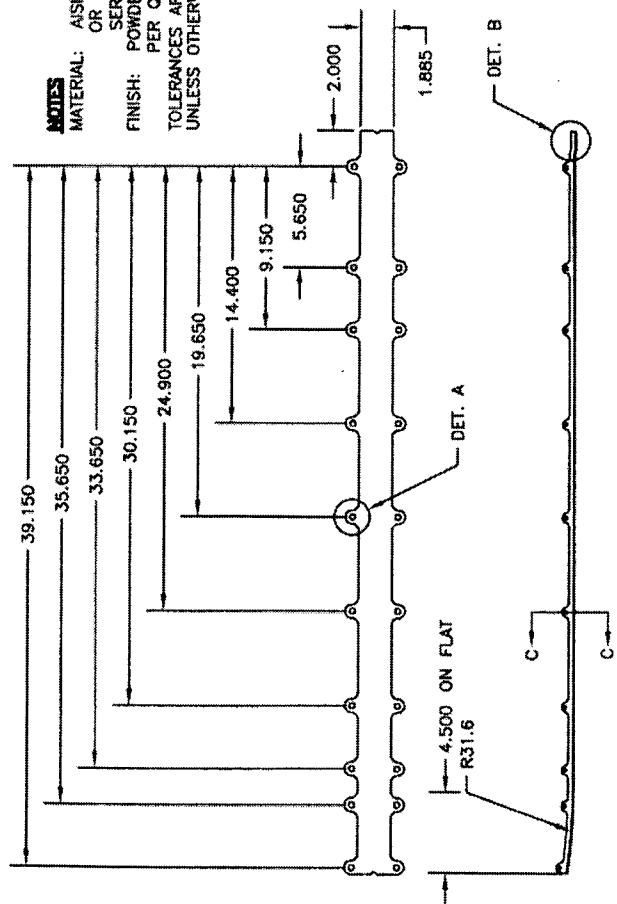
D2656-13



D2656-11



D2656-15



NOTES
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA C40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

RELEASED
05.09.08

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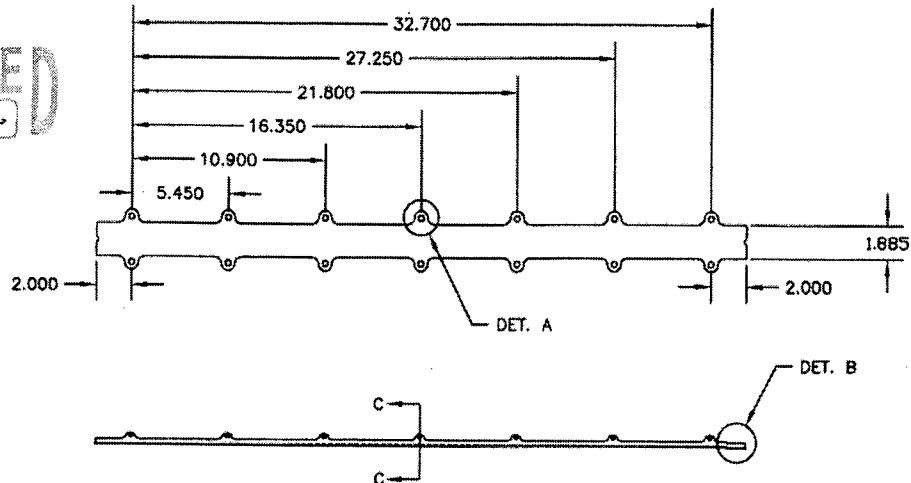
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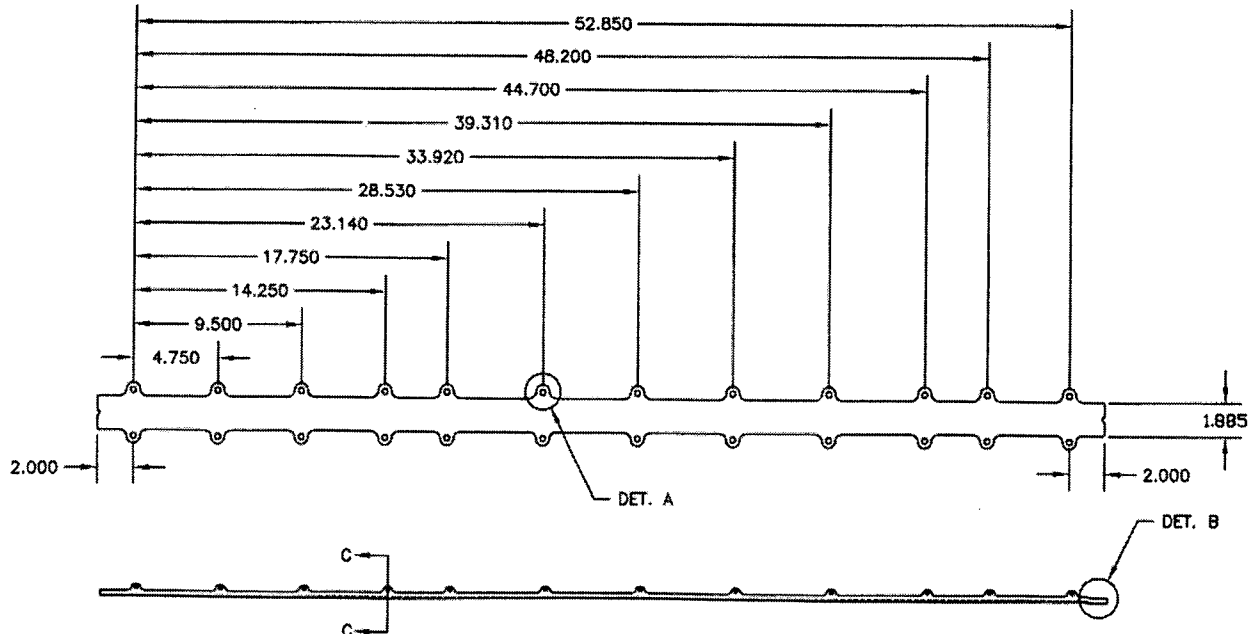
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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

RELEASED
05.07.06

D2656-21



D2656-23



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

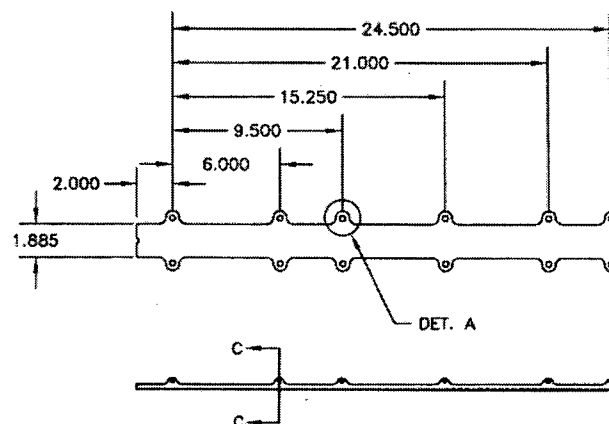
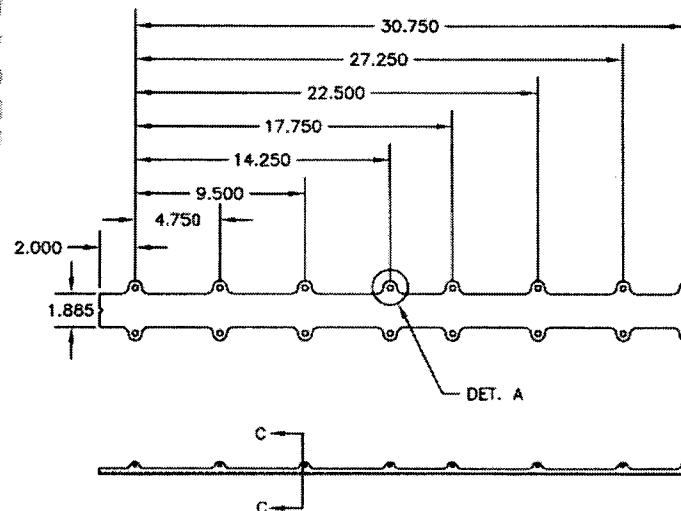
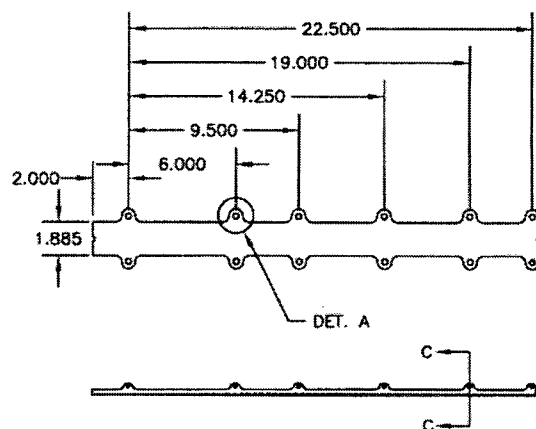
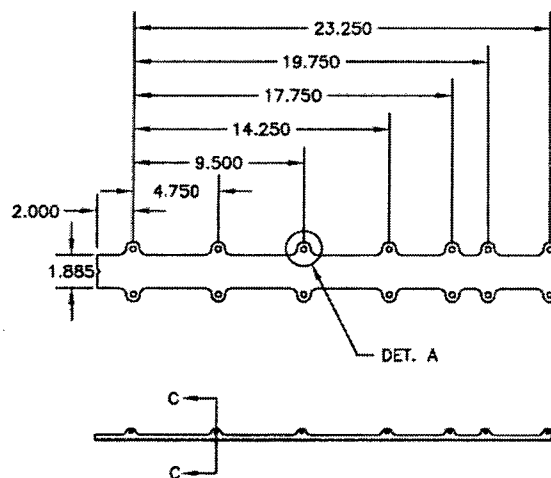
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DATE	05.08.17	DRAWING NO.	D2656	REV. D
		TITLE	WEARSHOE	SHEET 3 OF 4
		SCALE	1:10	

D2656-33**D2656-37****D2656-31****D2656-35****NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
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05-07-00

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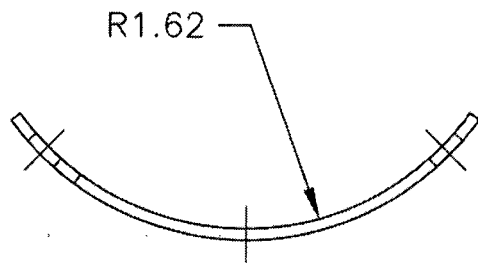
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

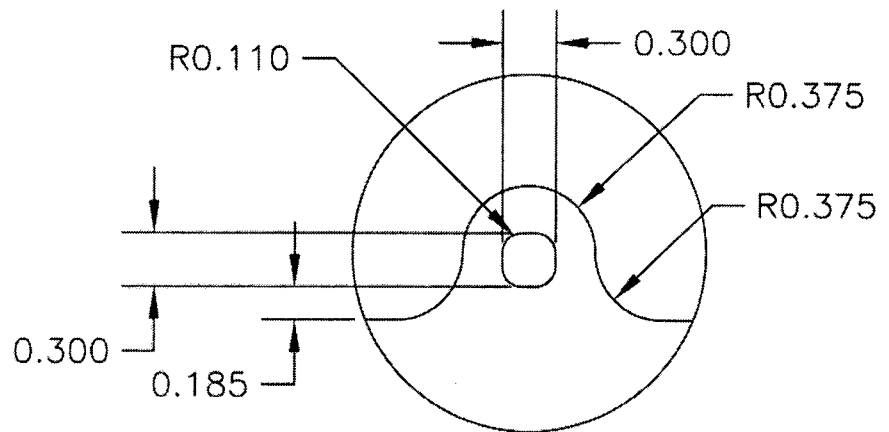
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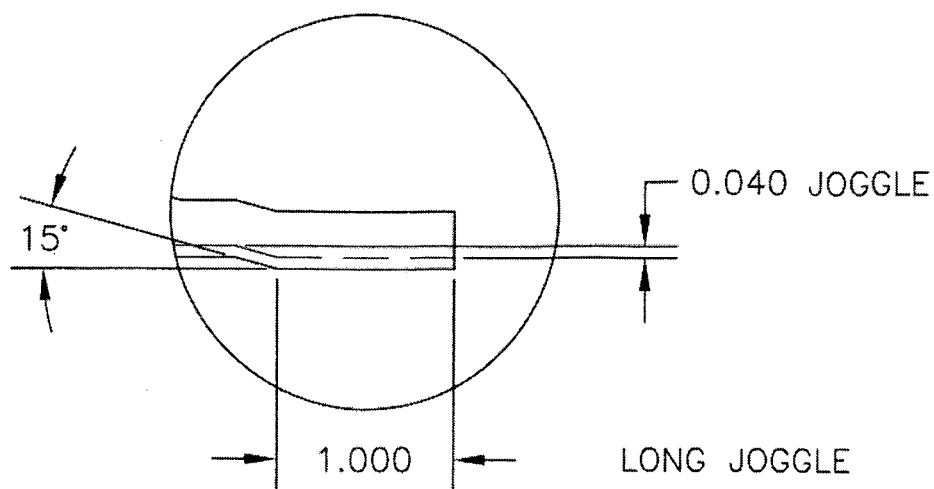
h/h/h

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05.09.06 *[Signature]*

DETAIL A



DETAIL B



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